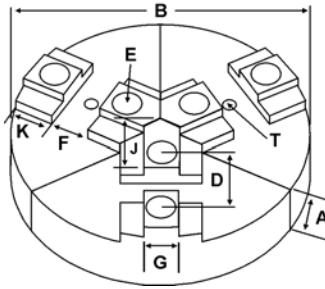
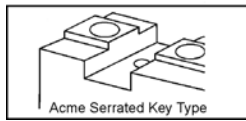


ROUND JAWS- ACME SERRATED KEY TYPE

FOR USE ON: **Cushman, Logansport, Howa, Autoblok, PBA & Other Chucks**



- Acme Serrated Key Type
- Round Jaws allow for complete gripping of workpiece
- Oversized jaws available
- Ideal for thin-walled or irregular shaped workpieces.
- Can be machined to fit workpiece
- All jaws have 2 holes
- Special "J" dimensions available
- Available in Aluminum & Cast Iron
- **Made in the USA**



Group
AI



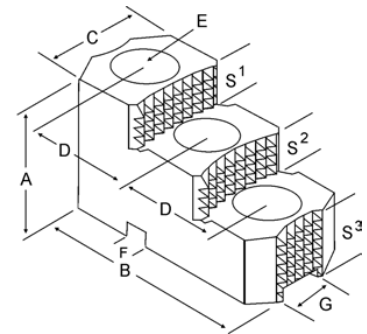
| Group No. | Chuck Size | Tap Hole T | Key to Front J | Critical Dimensions | | | | Pie Dia B | Hght Inch A | ALUMINUM | | CAST IRON | |
|--------------|------------|------------|----------------|---------------------|-------------|--------------|--------------|-----------|-------------|----------------|----------------|-------------|----------------|
| | | | | Groove Width G | Key Width F | Screw Size E | Hole Space D | | | Part Number | Price Set Of 3 | Part Number | Price Set Of 3 |
| Al-06-1/2-12 | 8 | 10-24 | 2.000 | 0.670 | 0.601 | 1/2 | 1.25 | 8 | 2.00 | RAC-8200A | \$103.98 | RAC-8200CI | \$115.20 |
| | | | | | | | | | 4.00 | RAC-8400A | \$145.57 | RAC-8400CI | \$217.59 |
| Al-07-1/2-17 | 10 | 5/16-18 | 2.750 | 0.750 | 1.031 | 1/2 | 1.75 | 10 | 2.00 | RAC-10200A | \$136.45 | RAC-10200CI | \$172.80 |
| | | | | | | | | | 4.00 | RAC-10400A | \$210.47 | RAC-10400CI | \$307.19 |
| | | | | | | | | | 12 | 2.00 | 12-RAC-10200A | \$177.32 | - |
| Al-08-5/8-20 | 12 | 5/16-18 | 3.250 | 0.875 | 1.031 | 5/8 | 2.00 | 12 | 2.00 | RAC-12200A | \$177.32 | RAC-12200CI | \$255.99 |
| | | | | | | | | | 4.00 | RAC-12400A | \$351.92 | - | - |
| Al-10-3/4-25 | 15 to 18 | 3/8-16 | 4.250 | 1.000 | 1.531 | 3/4 | 2.50 | 15 | 2.50 | RAC-15250A | \$392.31 | RAC-15250CI | \$477.98 |
| | | | | | | | | | 4.00 | RAC-15400A | \$481.98 | - | - |
| | | | | | | | | | 5.00 | RAC-15500A | \$753.41 | - | - |
| Al-12-7/8-30 | 21 - 24 | 3/8-16 | 4.550 | 1.250 | 1.531 | 7/8 | 3.00 | 18 | 4.00 | 18-RAC-15400A* | \$674.80 | - | - |
| | | | | | | | | | 4.00 | 18-RAC-21400A | \$674.80 | - | - |
| | | | 6.650 | 1.250 | 1.531 | 7/8 | 3.00 | 21 | 4.00 | RAC-21400A | \$899.87 | - | - |

Round Jaw Material: ALUMINUM-6061-T6 Bar Stock, CAST IRON-Gray, STEEL-1018. 18" & Larger- Aluminum Casting T6
For complete list of applicable chucks, see pages 632-644. * denotes non-stock item. Please allow 1 week manufacturing time.

HARD JAWS ACME KEY SERRATED



- Designed for first operation roughing, expect standard runout between **0.005-0.010**
- Reversible-suitable for OD & ID workholding.
- **XTRA BITE (-X)** -very aggressive bite. Has conical teeth for extra gripping power and ground body to provide improved runout.
- **GRIP-RITE-OEM Style (-U)** hard jaws have ground tips and provide better runout.
- **SHARK JAWS** have conical teeth for extra gripping power and black oxide for long life. Ideal for castings and scaly material. Made in the USA.
- 1 & 2 step jaws available.



XTRA BITE (-X)
Very aggressive grip, ground body and sides for improved runout.

| GROUP | Chuck Size | Critical Dimensions | | | | Tap Hole | Width Inch C | OAL Inch B | Height Inch A | No. of Holes | No. of Steps | Top Step Ht S1 | Mid Step Ht S2 | Bot Step Ht S3 | Part Number | Price Per Set |
|--------------|------------|---------------------|----------------|--------------|--------------|----------|--------------|------------|---------------|--------------|--------------|----------------|----------------|----------------|-------------|---------------|
| | | Groove Width G | Tongue Width F | Screw Size E | Hole Space D | | | | | | | | | | | |
| Al-07-1/2-17 | 10 | 0.750 | 1.031 | 1/2 | 1.750 | 5/16-18 | 1.750 | 4.250 | 2.480 | 2 | 2 | 0.600 | 0.600 | 1.280 | AC-100HJ2-X | \$586.76 |
| Al-08-5/8-20 | 12 | 0.875 | 1.031 | 5/8 | 2.000 | 5/16-18 | 1.750 | 4.875 | 2.469 | 2 | 2 | 0.550 | 0.550 | 1.369 | AC-120HJ2-X | \$754.41 |
| Al-10-3/4-25 | 15 & UP | 1.000 | 1.531 | 3/4 | 2.500 | 3/8-16 | 2.500 | 5.500 | 3.469 | 2 | 2 | 0.950 | 0.950 | 1.569 | AC-150HJ2-X | \$888.53 |

LATHE TOOLHOLDER BUSHINGS

Please See Pages 244-248 For More Information!



FEATURES:

- Increased step diameter for easy and perfect sealing.
- Concentric ground and diamond polished OD & ID resulting in a mirror smooth finish
- "Easy Entry" feature on OD for quick insertion
- Wrench flats for easy removal
- Step relief for easy removal and gripping on Z style bushings
- Type and size clearly marked on surface of head diameter for easy identification
- 100% Satisfaction Guaranteed



SPECIFICATIONS:

Material: ALLOY STEEL 8620
Hardness Data: Rc 55-57 for longer tool life
Case Hardened and Ground Concentric OD & ID
Axial Concentricity: OD & ID-.002"
Tolerance: H6 & g6 in grinding the OD & ID

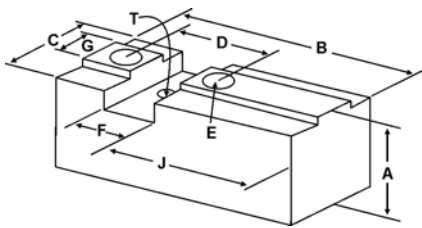
Call Us Today For All Of Your Machine Tool Needs!

2010-11 Master Catalog

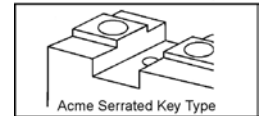
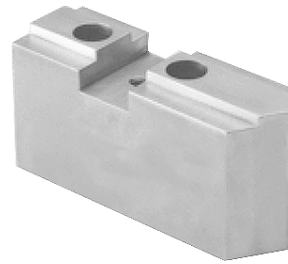
SOFT JAWS- ACME SERRATED KEY TYPE

C

FOR USE ON: **Cushman, Logansport, Howa, Autoblok, PBA & Other Chucks**



- Supplies maximum concentricity on finish turning operations
- Can be bored or turned to fit workpiece
- Steel jaws can be hardened
- Available flat ended or pointed for smaller diameter parts
- Special orders available
- Available in Aluminum, Steel & Aircraft Aluminum (where noted)
- **Made in the USA**



QUANTITY DISCOUNTS!
Order **5 SETS OR MORE** of the same part number soft jaw and receive a **5% DISCOUNT!**

LATHES CHUCKS
LIVE CENTERS

WISE JAWS
WISE ACCESSORIES

STRAIGHT SHANK
COLLET HOLDERS

LATHES BUSHINGS
DRILL CHUCKS

CARBIDE INSERTS
THREADING/GROOVING

CUTTING TOOLS
MACHINERY

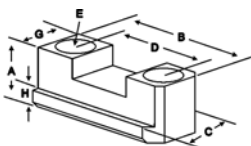
PRECISION TOOLS
DEBURRING

COOLANT/FLUIDS
TOOL STORAGE

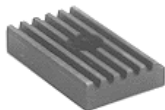
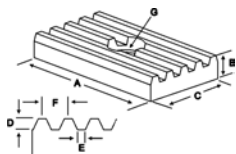
| Group No. | Chuck Size | Tap Hole T | Key to Front J | Critical Dimensions | | | | ALUMINUM | | | | STEEL | | |
|--------------|------------|------------|----------------|---------------------|-------------|--------------|--------------|--------------|---------------|-------------|----------------------|----------------|----------------------|----------------|
| | | | | Groove Width G | Key Width F | Screw Size E | Hole Space D | Width Inch C | Length Inch B | Hght Inch A | FLAT END Part Number | Price Set Of 3 | FLAT END Part Number | Price Set Of 3 |
| AI-06-1/2-12 | 8 | 10-24 | 2.000 | 0.670 | 0.601 | 1/2 | 1.250 | 1.50 | 3.75 | 2.00 | AC-8200AF | \$57.20 | AC-8200F | \$61.24 |
| | 9 | 10-24 | 2.000 | 0.670 | 0.601 | 1/2 | 1.250 | 1.50 | 3.75 | 4.00 | AC-8400AF | \$80.63 | AC-8400F | \$87.48 |
| AI-07-1/2-17 | 10 | 5/16-18 | 2.250 | 0.750 | 1.031 | 1/2 | 1.750 | 1.75 | 4.25 | 2.50 | AC-10250AF | \$64.75 | AC-10250F | \$68.90 |
| | | | | | | | | | | 4.00 | AC-10400AF | \$86.64 | AC-10400F | \$91.85 |
| | | | 3.425 | 0.750 | 1.031 | 1/2 | 1.750 | 1.75 | 5.50 | 2.50 | AC-10251AF* | \$70.56 | AC-10251F* | \$76.56 |
| | | | | | | | | | | 4.00 | AC-10401AF* | \$91.59 | AC-10401F* | \$99.36 |
| AI-08-5/8-20 | 12 | 5/16-18 | 3.125 | 0.875 | 1.031 | 5/8 | 2.000 | 1.75 | 5.25 | 2.50 | AC-12250AF | \$72.08 | AC-12250F | \$76.56 |
| | | | | | | | | | | 3.00 | AC-12300AF | \$95.21 | AC-12300F | \$101.30 |
| | | | | | | | | | | 4.00 | AC-12400AF | \$94.16 | AC-12400F | \$99.51 |
| | | | | | | | | | | 5.00 | AC-12500AF | \$143.91 | AC-12500F | \$152.82 |
| | | | | | | | | | | 2.50 | AC-12250AF | \$72.08 | AC-12250F | \$76.56 |
| AI-10-3/4-25 | 15 - 18 | 3/8-16 | 3.000 | 1.000 | 1.531 | 3/4 | 2.500 | 2.00 | 6.25 | 2.50 | AC-15250AF | \$86.74 | AC-15250F | \$91.85 |
| | | | | | | | | | | 4.00 | AC-15400AF | \$109.16 | AC-15400F | \$114.82 |
| | | | | | | | | | | 2.50 | AC-18250AF | \$108.54 | AC-18250F | \$114.82 |
| | | | 3.400 | 1.000 | 1.531 | 3/4 | 2.500 | 2.50 | 6.25 | 4.00 | AC-18400AF | \$131.85 | AC-18400F | \$129.54 |
| | | | | | | | | | | 5.00 | AC-18500AF | \$167.98 | AC-18500F | \$182.24 |
| | | | | | | | | | | 4.00 | AC-21400AF | \$131.85 | AC-21400F | \$138.37 |
| AI-12-7/8-30 | 21 - 24 | 3/8-16 | 2.625 | 1.250 | 1.531 | 7/8 | 3.000 | 2.50 | 6.50 | 4.00 | AC-21400AF | \$131.85 | AC-21400F | \$138.37 |
| | | | | | | | | | | 5.00 | AC-21500AF | \$181.57 | AC-21500F | \$191.36 |

For "Pointed" Soft Jaws, please substitute "P" for "F" in the part number. Example: AC-8200AF will be AC-8200AP. Pointed Jaws: Up to 10" add \$3.25, 12" & over add \$6.50.
Soft Jaw Material: ALUMINUM-6061-T6 Bar Stock, STEEL-1018, "B" JAWS-7075-T6 Aircraft Aluminum
For complete list of applicable chucks, see pages 632-644. * denotes non-stock item. Please allow 1 week manufacturing time.

JAW NUTS & MASTER KEYS



| Chuck Size | Heel Height H | Groove Width G | Screw Size E | Holes Space D | Hght Inch A | Width Inch C | Length Inch B | 2 Screws Included With Each Jaw Nut | | | |
|------------|---------------|----------------|--------------|---------------|-------------|--------------|---------------|-------------------------------------|------------|-------------------|------------|
| | | | | | | | | Jaw Nut Part Number | Price Each | Screw Part Number | Price Each |
| 8 | 0.440 | 0.667 | 1/2-13 | 1.250 | 1.000 | 1.030 | 2.00 | AC-80JN | \$48.88 | S1/213150 | \$2.00 |
| 10 | 0.380 | 0.677 | 1/2-13 | 1.750 | 0.641 | 0.940 | 2.50 | AC-100JN | \$44.33 | S1/213150 | \$2.00 |
| 12 | 0.440 | 0.801 | 5/8-11 | 2.000 | 0.744 | 1.060 | 3.00 | AC-125JN | \$46.37 | S5/811150 | \$3.00 |
| 15 - 18 | 0.550 | 0.933 | 3/4-10 | 2.500 | 0.930 | 1.250 | 3.50 | AC-155JN | \$48.88 | S3/410175 | \$4.00 |
| 21 - 24 | 0.684 | 1.158 | 7/8-9 | 3.000 | 1.185 | 1.554 | 4.25 | AC-215JN | \$61.09 | S7/809175 | \$5.50 |



| Chuck Size | Screw Size G | Pitch F | Slot E | Depth D | Critical Dimensions | | | | | Price Each |
|------------|--------------|---------|--------|---------|---------------------|---------------|---------------|------------------------|---------|------------|
| | | | | | Width Inch C | Height Inch B | Length Inch A | Master Key Part Number | | |
| 8 | 10-24 | 0.156 | 0.093 | 0.130 | 0.600 | 3/8" | 1.500 | AC-80AK | \$29.26 | |
| 10-12 | 5/16 | 0.250 | 0.093 | 0.130 | 1.030 | 1/2" | 1.687 | AC-120AK | \$31.70 | |
| 10-12 | 3/8 | 0.250 | 0.093 | 0.130 | 1.187 | 1/2" | 2.000 | AC-125AK | \$36.57 | |
| 15-18 | 3/8 | 0.250 | 0.093 | 0.130 | 1.530 | 1/2" | 2.000 | AC-150AK | \$39.01 | |
| 15-18 | 3/8 | 0.250 | 0.093 | 0.130 | 1.530 | 1/2" | 2.437 | AC-180AK | \$39.01 | |
| 21-24 | 3/8 | 0.250 | 0.093 | 0.130 | 1.530 | 1/2" | 2.875 | AC-210AK | \$40.23 | |

Call Us Or Visit Our Website For Our Complete Selection!

2010-11 Master Catalog